

Work Order ID 62982

Thursday, October 14, 2010 3:06:24 PM

Page 1

Item ID: D3684-047

Accept

Setup Start

Revision ID:

Stop

Item Name: FWD LEG ASS'Y

Start Date: 10/15/2010 Start Qty: 4.00

Required Date: 10/22/2010 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mk*

Date: 10-10-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3684

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

**Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3684*SB 11604601**(4)**SB 11604601**(4)*

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

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Work Order ID: 62982

Parent Item: D3684-047

Parent Item Name: FWD LEG ASS'Y



Start Date: 10/15/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A Bolts		Purchased	No			110	Each	38.0000	2	8			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>ST351</div> <div>38</div> <div></div> </div> <div> <div>112314</div> <div>8</div> <div></div> </div> <div> <div>114761</div> <div>11</div> <div></div> </div> <div> <div>115392</div> <div>4</div> <div></div> </div> <div> <div>115594</div> <div>15</div> <div></div> </div>													
D3688-1 STUD		Manufactured	No			110	Each	8.0000	1	4			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>ST075</div> <div>8</div> <div></div> </div> <div> <div>58635</div> <div>4</div> <div></div> </div> <div> <div>59668</div> <div>4</div> <div></div> </div>													
D3689-1 SLEEVE		Manufactured	No			110	Each	4.0000	1	4			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>ST76</div> <div>4</div> <div></div> </div> <div> <div>62188</div> <div>4</div> <div></div> </div>													

B65344

(4)

SR 11/03/31

SR 11/03/31

SR 11/03/31

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Parent Item: D3684-047

Parent Item Name: FWD LEG ASS'Y

Start Date: 10/15/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

D3691-1

Manufactured No

110

Each

23.0000

1

4



STUD



SB 11/03/11

Location

Loc Qty

Loc Code

ST077

16

61370

16

1

ST082

7

58631

7

3

D3692-1

Manufactured No

110

Each

281.0000

4

16



SPACER



SA 11/03/11

Location

Loc Qty

Loc Code

ST082

281

51467

281

14

D3693-1

Manufactured No

110

Each

32.0000

1

4



Rod End Bearing



SA 11/03/11

Location

Loc Qty

Loc Code

ST082

32

50734

32

4

MS21043-3

Purchased No

110

Each

2,548.000

2

8



Nut



SA 11/03/11

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2472

111383

23

112314

2449

8

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Shop Packet Print

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Parent Item Name: FWD LEG ASS'Y

Start Date: 10/15/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

NAS509-12C

Purchased

No

110

Each

38.0000

1

4



Nuts



SB 11/03/31

Location

Loc Qty

Loc Code

ST280

38

112453

38

4

NAS509L12C

Purchased

No

110

Each

43.0000

1

4



Nuts



SB 11/03/31

Location

Loc Qty

Loc Code

ST280

43

112314

33

112828

10

4

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Page 3

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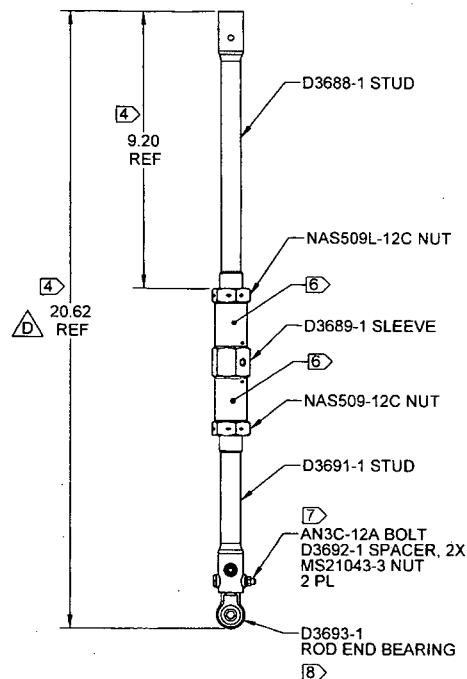
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-047 FWD LEG ASSEMBLY

RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.09 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3684	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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